

Work Order ID 71995

Friday, July 15, 2011 9:08:31 AM

Page 1

PRELIMINARY ISSUE

Item ID: D4331-3

Revision ID: PRELIM

Item Name: Angle

Start Date: 7/14/2011 Start Qty: 1.00

Required Date: 7/15/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4331

PA1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4331

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Accept

Cust Item ID:

Customer:

Setup Start

Stop

AS 11/07/15

AS 11/07/15

E 11.07.15

Work Order ID 71995

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Item ID: D4331-3

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Item Name: Angle

Start Date: 7/14/2011 Start Qty: 1.00

Required Date: 7/15/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

FORM AS PER DWG

0.00

0.00

SB 4/6/18

①

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

- inspect to PAJ

Day only
(Best Room only)

8/10/18

④

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

1 & BL 11-7-19

Work Order ID 71995

Friday, July 15, 2011 9:08:31 AM

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Item ID: D4331-3

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Item Name: Angle

Start Date: 7/14/2011 Start Qty: 1.00

Required Date: 7/15/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Tooling: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 of 2404/19

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

1 E 7.07.19

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

what job?
RD2334

POSITIVE RECALL
EFFECTIVE DATE
RELEASED AUTH
POSITIVE RECALL
EFFECTIVE DATE
RELEASED AUTH

u 7.07.19

Picklist Print

Friday, July 15, 2011 9:08:28 AM

Page 1

Work Order ID: 71995

Parent Item: D4331-3

Parent Item Name: Angle




Start Date: 7/14/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-05 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063  2024-T3 .063 sheet		Purchased	No				sf	250.3800		0.3			



Location

Loc Qty

Loc Code

MAT022

250.38

117018

25.88

117392

224.5

114351

13 ~~11~~ 11/07/15

DART AEROSPACE LTD		Work Order:	71995
Description: Angle		Part Number:	DY331-3 Bent
Inspection Dwg: D4331	Rev: D4	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

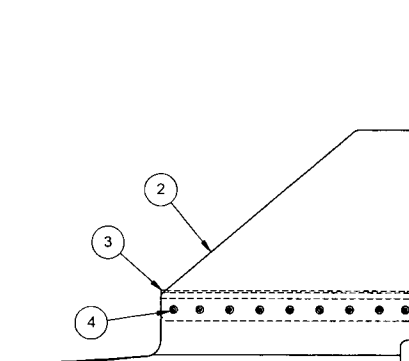
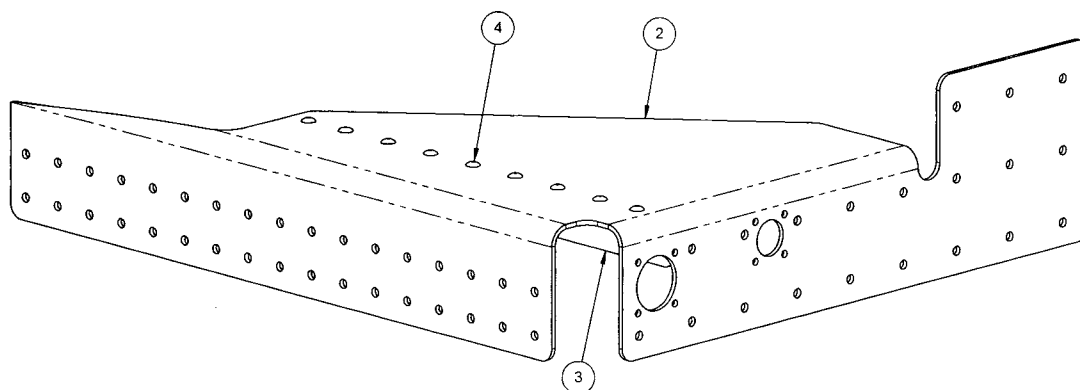
☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: <i>SB</i>		Audited by: <i>S</i>		Prototype Approval: N/A	
Date: <i>11/07/18</i>		Date: <i>11/07/18</i>		Date: N/A	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4331-041	DOUBLER ASSEMBLY
2	1	D4331-1	DOUBLER
3	1	D4331-3	ANGLE
4	9	MS20470AD4-3	RIVET



D4331-041 DOUBLER ASSEMBLY

W/0 FIAAS

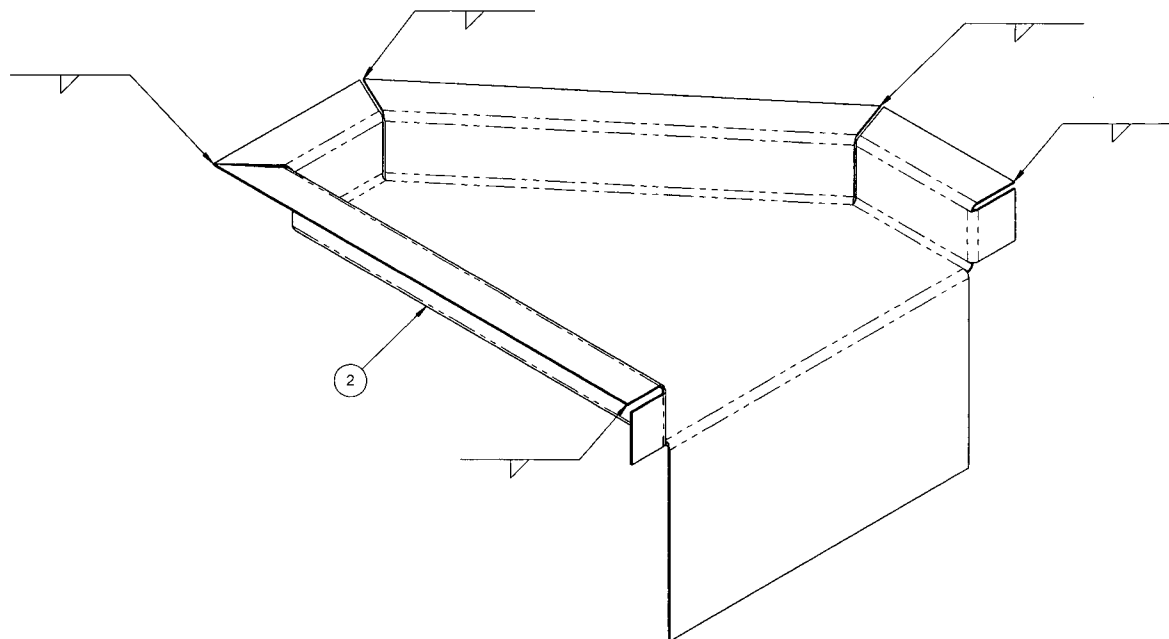
PRELIMINARY ISSUE

11.02.03

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.34 lbs

PA1	NEW ISSUE	DESCRIPTION	BY	DATE
REV.				
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. PA1	
MFG. APPR.		D4331	SHEET 1 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		DOUBLER	NTS	
DATE	11.02.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD		
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4331-043	FIREWALL ASSEMBLY
2	1	D4331-5	FIREWALL

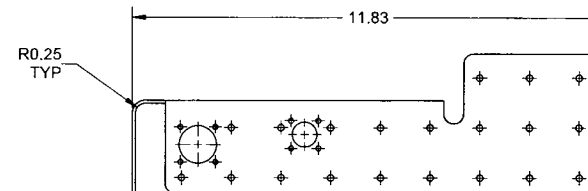
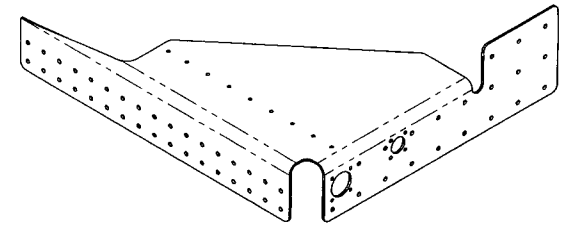
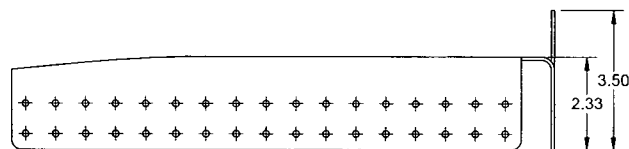
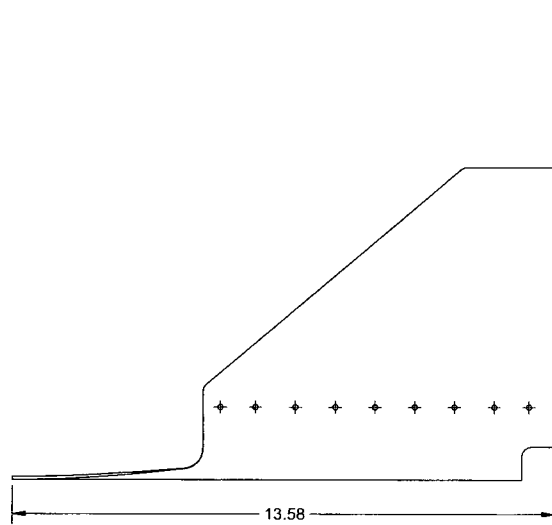


D4331-041 FIREWALL ASSEMBLY

PRELIMINARY ISSUE

11.02.03

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
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D4331-1 DOUBLER

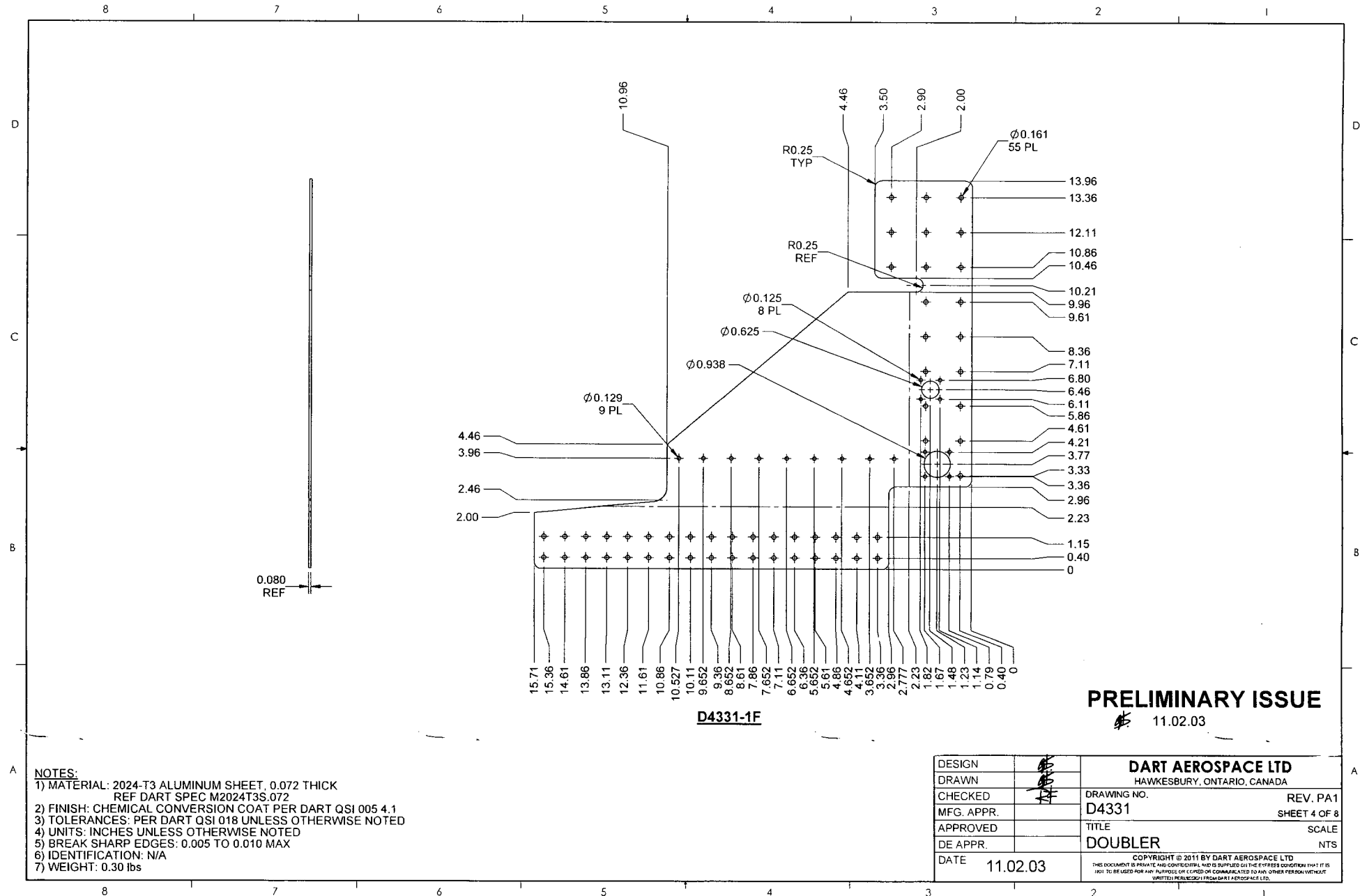
PRELIMINARY ISSUE

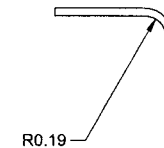
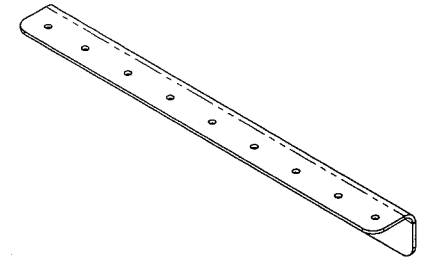
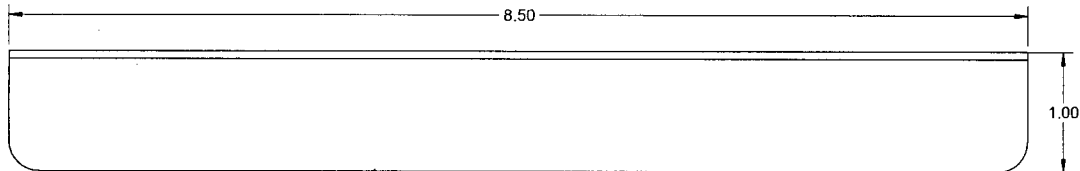
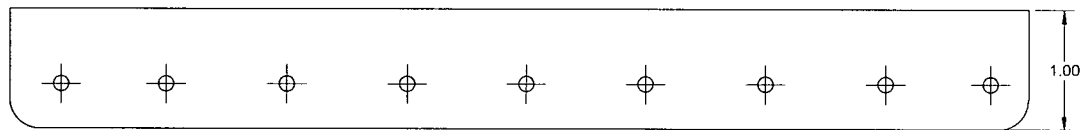
11.02.03

NOTES:

- 1) MATERIAL: MADE FROM D4331-1F
- 2) FINISH: PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4331	SHEET 3 OF 8
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D4331-3 ANGLE

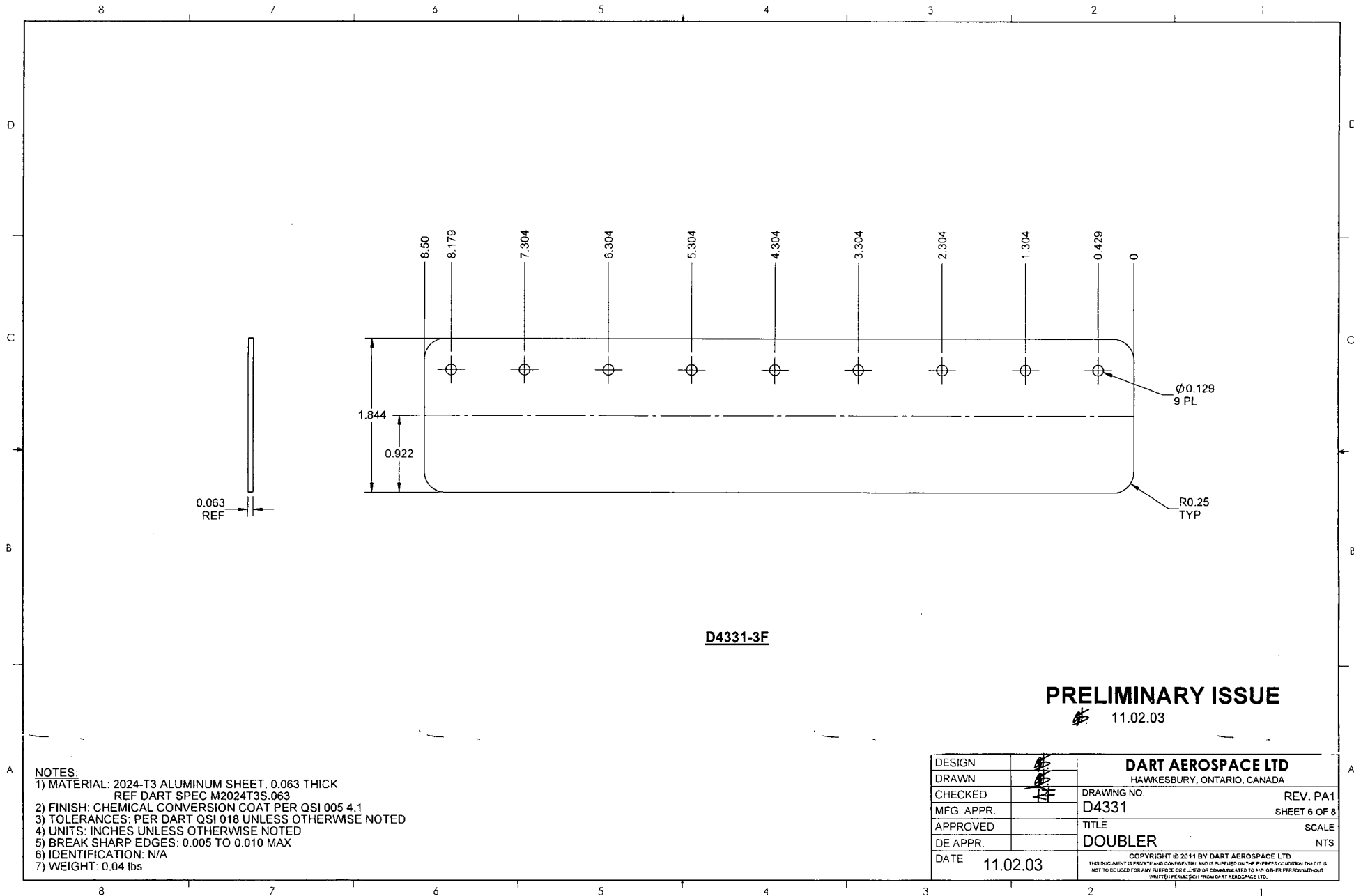
PRELIMINARY ISSUE

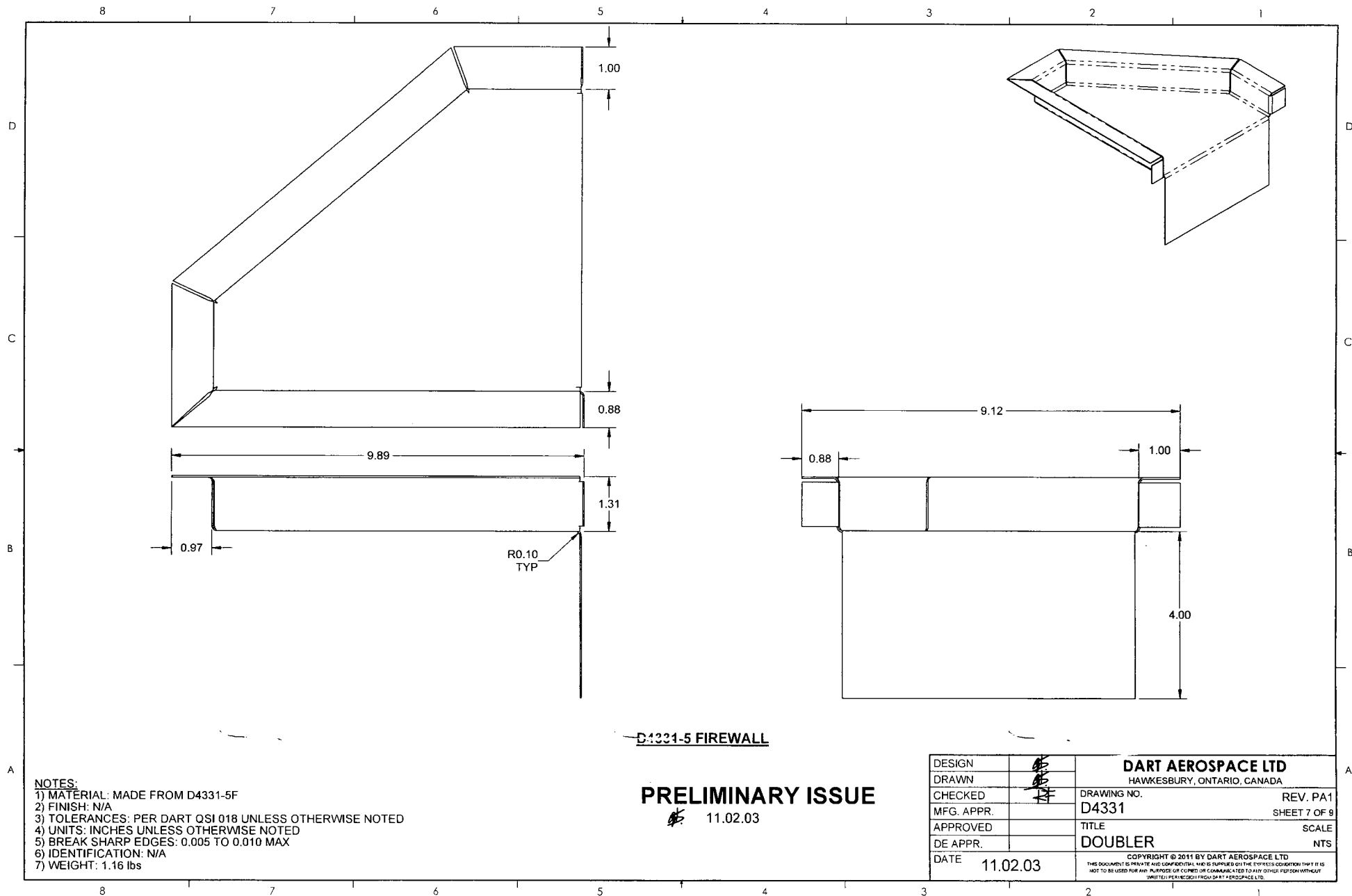
11.02.03

NOTES:

- 1) MATERIAL: MADE FROM D4331-3F
- 2) FINISH: PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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D4331-5 FIREWALL

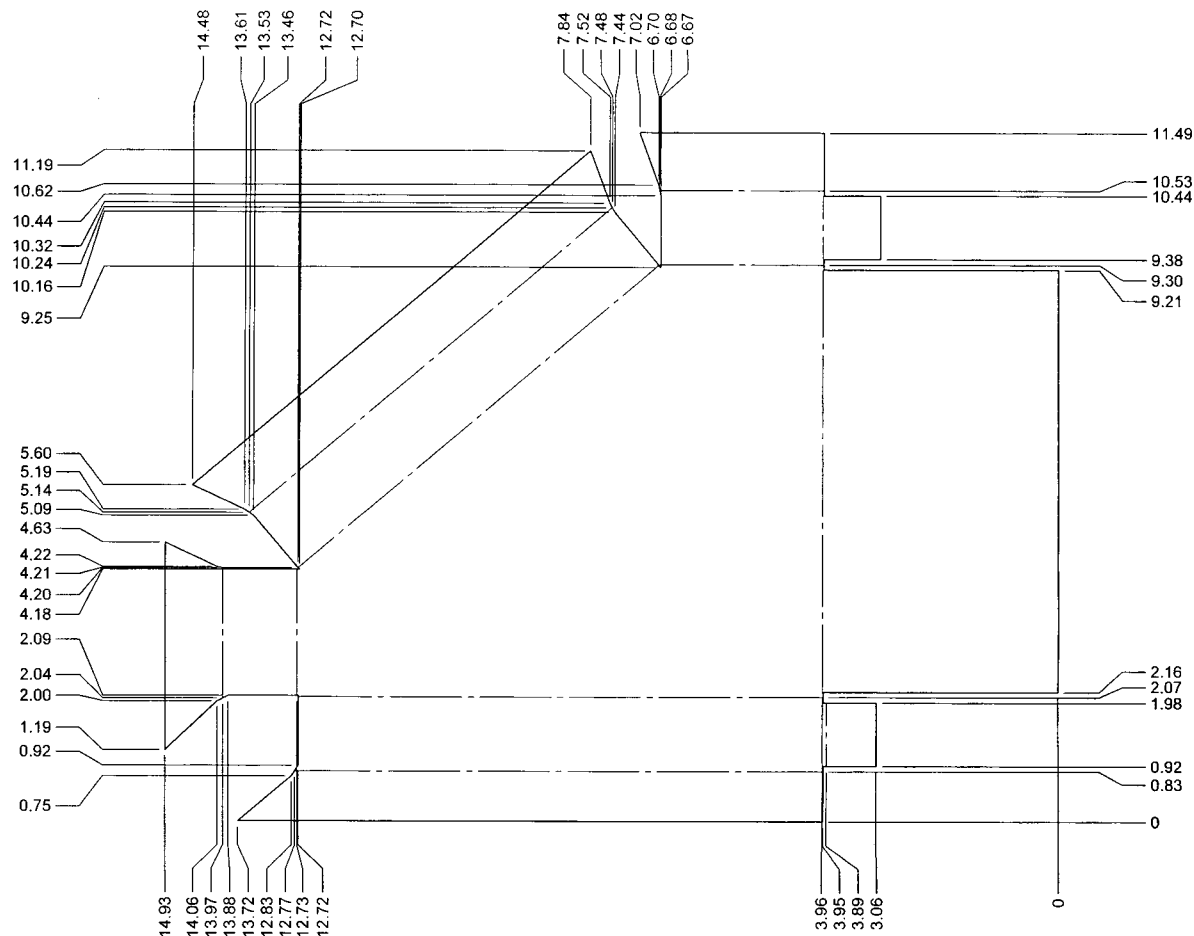
PRELIMINARY ISSUE

11.02.03

NOTES:

- 1) MATERIAL: MADE FROM D4331-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
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D4331-5F

PRELIMINARY ISSUE

11.02.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER MIL-S-5059
OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S22GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4331	SHEET 8 OF 9
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